

Work Order ID 70455

Wednesday, June 08, 2011 3:48:19 PM



Page 1

Item ID:	D3017-041	Accept		Setup	Start	
Revision ID:						
Item Name:	Back Frame Assembly				Stop	
Start Date:	6/8/2011	Start Qty:	1.00			
Required Date:	6/10/2011	Req'd Qty:	1.00			
Reference:						

Approvals:	Process Plan:		Date:	1-06-08	Tooling:		Date:		Run	Start	
	QC:		Date:		SPC (Y/N):		Date:			Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3017	Rev B								

100 Weld per dwg A/R 4130 rod Batch: M100075 0.00
 Large Fab
 Memo 0.00
 1-Cut D3017-1, D3017-3 and D3017-5 tubes as per Dwg D3017
 2-Bend D3017-1 and D3017-3 tube as per dwg D3017 (DT8598)
 3-Drill holes in D3017-5 Using DT8622
 4-Deburr
 5-Assemble and weld as per Dwg D3017 using Welding Jig DT8598
 6-Drill holes in back frame using DT8621

EL 11-6-13

Pro →

110 QC9- Inspect visual per QSI004- Fusion Welds 0.00
 QC
 Memo 0.00
 Quality Control

1 0 8/11/06/13

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3017-041 PAR #: _____ Fault Category: Large Job NCR: Yes No DQA: JA Date: 11.06.21
 11-6661 Resolution: Scrap Disposition: Scrap QA: N/C Closed: OK Date: 11/06/21

NCR: <u>70455</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
<u>11/06/21</u>	<u>100</u>	<u>Back Frame is Bent cracked. when transfer Drilling the Back Panel it was found that it is fl.</u>	<u>[Signature]</u> <u>11/06/21</u>	<u>-Scrap + Destroy + Re-line</u>	<u>EL</u> <u>11-6-13</u>	<u>[Signature]</u> <u>11/06/21</u>	<u>[Signature]</u> <u>11/06/21</u>	<u>[Signature]</u> <u>11/06/21</u>
		<u>R-C Process</u>						

NOTE: Date & initial all entries

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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

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Work Order ID: 70455




Parent Item: D3017-041

Parent Item Name: Back Frame Assembly

Start Date: 6/8/2011**Required Date:** 6/10/2011**Start Qty: 1.00**

Required Qty: 1.00

Comments: IPP A□01.09.19□New issue EC□
IPP RevB: as per revB DD verified by:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M4130NT0.750W.083 		Purchased	No			100	f	63.6470	2.458	2.587368			
4130 RD Tube .750 x.083W													
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				MAT033				63.647					
				<u>117579</u>				39.73					
				117973				23.917					
M4130NT0.750W.049 		Purchased	No			100	f	100.0990	11.125	11.71053			
4130 RD Tube .750 x.049W													
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				MAT033				100.099					
				110740				1.129					
				117691				46.97					
				117973				52					
D3017-11 		Manufactured	No			100	Each	24.0000	2	2			
cap													
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				WA				24					
				<u>69074</u>				24					

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NOTE: Date & initial all entries

Picklist Print

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Work Order ID: 70455



Parent Item: D3017-041



Parent Item Name: Back Frame Assembly

Start Date: 6/8/2011

Required Date: 6/10/2011

Start Qty: 1.00

Required Qty: 1.00

D3017-7

Manufactured

No

100

Each

11.0000

3

3



EL 116-13

Lug

Location

Loc Qty

Loc Code

WA

10

69166

10

6

WA019

1

52915

1

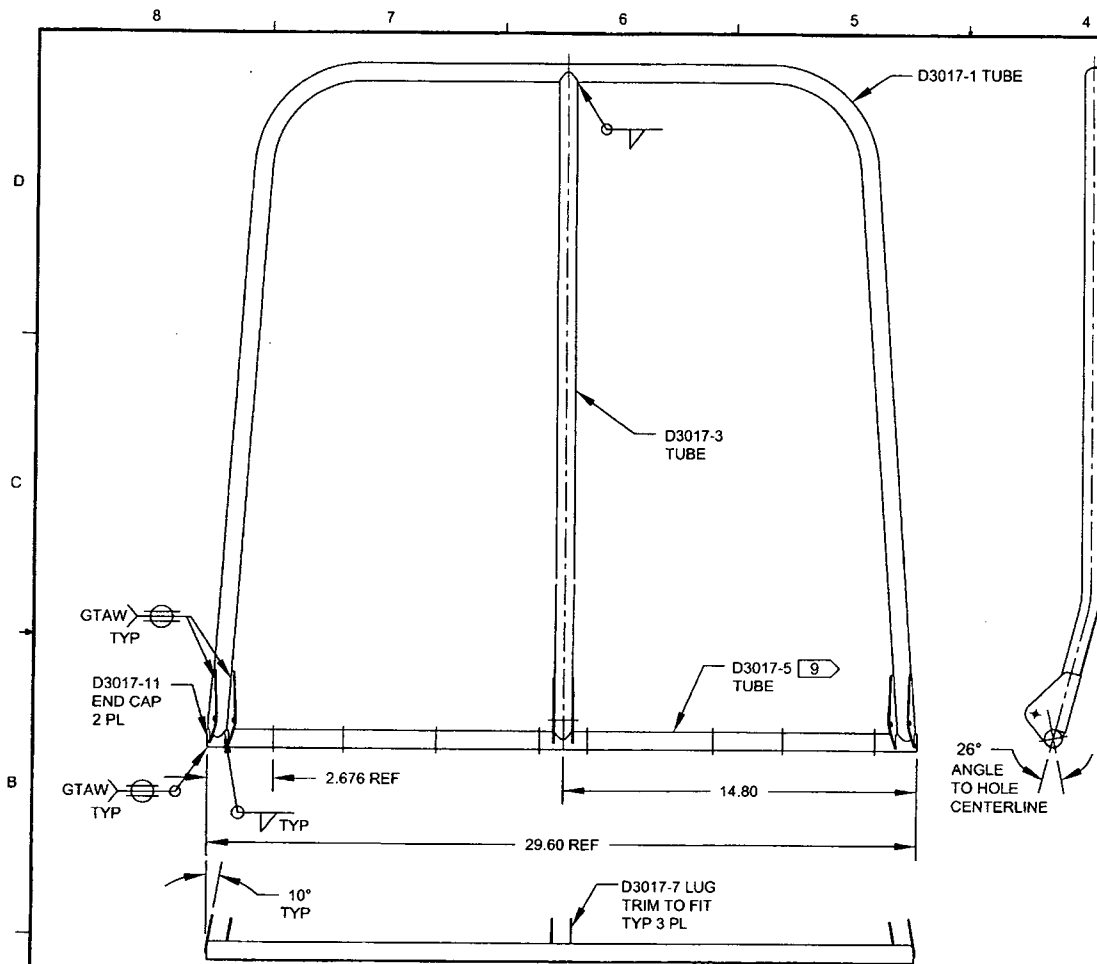
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ITEM No.	QTY	PART NUMBER	DESCRIPTION
1	X	D3017-041	BACK FRAME ASSEMBLY
2	1	D3017-1	TUBE
3	1	D3017-3	TUBE
4	1	D3017-5	TUBE
5	3	D3017-7	LUG
6	2	D3017-11	END CAP

DRILL Ø0.128 HOLES TO LINE UP WITH D3023-1 BACK PANEL

#70456

RELEASED
R 2010-02-02
WP

D3017-041 BACK FRAME ASSEMBLY

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3017-041" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 4.50 lbs
- 8) WELD PER DART QSI 004
- 9) ROTATE SO THAT PILOT HOLES ARE ANGLED AS SHOWN IN END VIEW.

B	REFORMAT DWG, -5 TUBE WALL THKNS REV'D (A8-3) SHEET 3 & 4 ADDED TO CLARIFY DRAWING. RADIUS CHANGED FROM R4.00 TO R3.75 (B4-2, B2-2). HOLE SIZE CHANGED FROM Ø0.191 TO Ø0.257 (C6-3, C3-3)	JPH	10.01.13
A	NEW ISSUE	CP	01.05.18
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	10.01.13		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. REV. B
D3017 SHEET 1 OF 4
TITLE SCALE
BACK FRAME ASSEMBLY NTS

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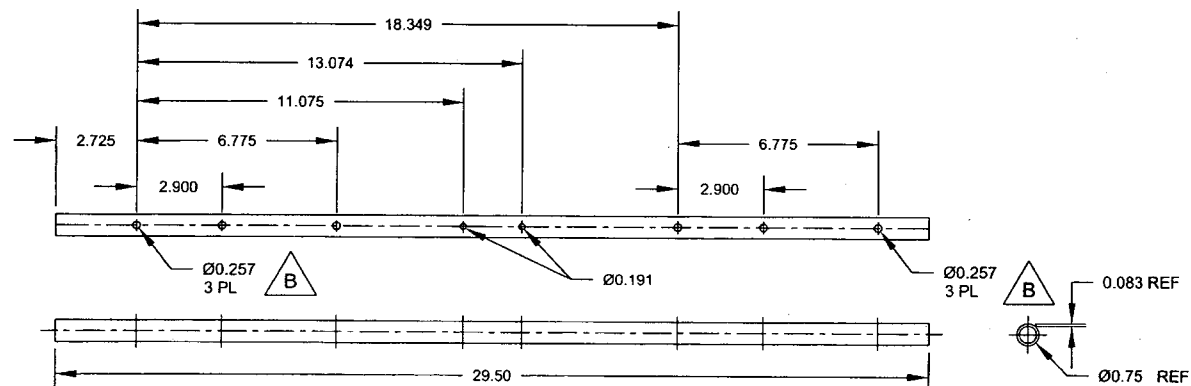
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NOTE: Date & initial all entries



D3017-5 TUBE

RELEASED
2010-02-02

NOTES:

- 1) MATERIAL: AISI 4130N TUBE, Ø0.75 DIA x 0.083 WALL (M4130N-T0750W083)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.89 lbs



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DRAWN		HAWKESBURY, ONTARIO, CANADA	
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MFG. APPR.	<i>JE</i>	D3017	SHEET 3 OF 4
APPROVED	<i>JA</i>	TITLE	SCALE
DE APPR.	<i>JA</i>	BACK FRAME ASSEMBLY	NTS
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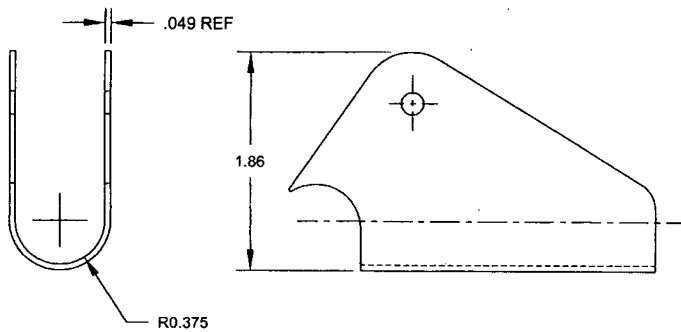
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

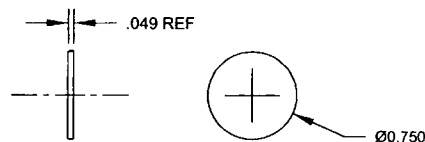
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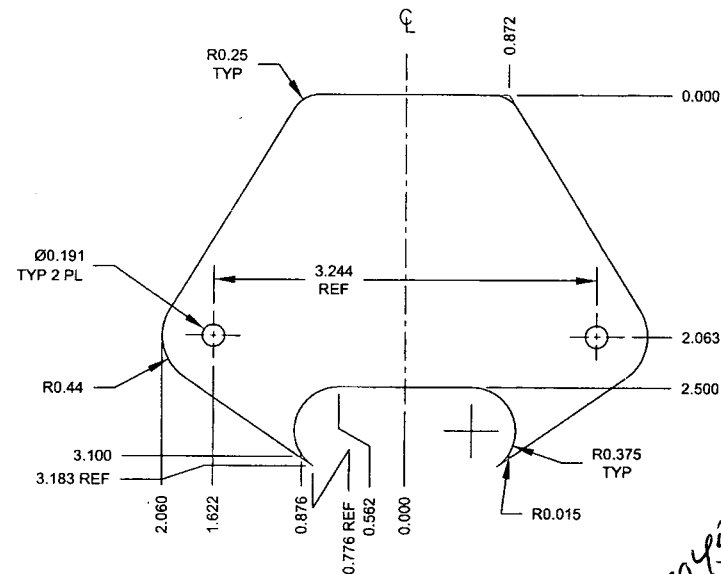
8 7 6 5 4 3 2 1



D3017-7 LUG
BENDING DETAIL
MAKE FROM D3017-7F



D3017-11 END CAP



D3017-7F FLAT PATTERN
PART IS SYMMETRIC
ABOUT CENTERLINE

70435

RELEASED
2010-02-02

NOTES:

- 1) MATERIAL: AISI 4130N SHEET, 18 GAUGE (M4130N-S049)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: -7: 0.12 lbs; -11: 0.01 lbs.

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MFG. APPR.	<i>[Signature]</i>	D3017	SHEET 4 OF 4
APPROVED	<i>[Signature]</i>	TITLE	SCALE
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8 7 6 5 4 3 2 1

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